

Date: Tuesday, 6/19/2007 2:03:22 PM  
 User: Kim Johnston

## Process Sheet

31

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BEARPAW KIT (EC 135)  
 Job Number : 32938  
 Estimate Number : 10536  
 P.O. Number : N/A Part Number : D135692011  
 This Issue : 6/19/2007 S.O. No. : N/A Drawing Number : D3049 REV A1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A1  
 Previous Run : 30542 Material : N/A  
 Due Date : 7/30/2007 Qty: 4 Um: Each  
 Written By :  
 Checked & Approved By : 07.06.20  
 Comment : Est Rev: C 04.02.17 Blank size changed, Tolerance added Step  
 3 KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



K3 07.07.26 (4)

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D135-692-011 CHG002

J.F. 07/10/16

2.0

MUHMWB10

UHMW 1" Black



Comment: Qty.: 5.4810 sf(s)/Unit Total : 21.9240 sf(s)

blank: 16.00" x 23.50" x 1.00" thick (+0.030/-0.000)

per DSK086-9

Material: Black UHMW 1"(MUHMWB10)

Batch: M105863

J.F. 07/10/16

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA165 and Dwg D3049 Identify as D3049-1

3-Deburr

J.F. 07/10/16 (8)

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/10/16 (8)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 6/19/2007 2:03:22 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (EC 135)

Job Number: 32938

Part Number: D135692011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SP 07/10/17 (F)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 0.5000 f(s)/Unit Total : 2.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B060

Rubber Cushion

B30872

8.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274

Radius Block

B32015

9.0

D2519

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2519

Clamp

B326216

10.0

D2529

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529

Washer

B32025

11.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-15A

Bolt

M104072

SP 07/10/17 (F)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 07/10/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/19/2007 2:03:22 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (EC 135)

Job Number: 32938

Part Number: D135692011

Job Number:



Seq. #:

Machine Or Operation:

Description :

HT 12.0

AN960JD416

Washer



PS.



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN960JD416 Washer M105426

HT 13.0

MS21042L4

Nut



PS.



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 Nut (or -4) M104683

HT 14.0

QS100M24S

Clamp



PS.



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3049-1(ref) Bearpaw M10348(1A) M10364(15X)

4 QS100M24S Clamp

1 Paperwork package from Step 2(ref)

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D135-692-011

Location: C

PPP Rev: 7/10/17 SC

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07-10-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 32938
<b>Description:</b> Bearpaw		<b>Part Number:</b> D3049-1
<b>Inspection Dwg:</b> D3049	<b>Rev:</b> A1	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø0.260	+0.005/-0.000	0.259"	✓			
B	0.93	+/-0.030	0.931"	✓			
C	0.40	+0.030/-0.000	0.407"	✓			
D	2.00	+/-0.030	2.017"	✓			
E	10.250	+/-0.010	10.250"	✓			
F	4.540	+/-0.030	4.541"	✓			
G	5.88	+/-0.030	5.876"	✓			
H	0.38	+/-0.030	0.377"	✓			
I	15.50	+/-0.030	15.500"	✓			
J	0.07 x 45°	+0.030/-0.010	0.060"	✓			
K	0.44 - 0.47	+/-0.000	0.440"	✓			
L	R0.25	+/-0.030	R0.250	✓			
M	0.38	+/-0.010	0.382"	✓			
N	0.95	+0.030/-0.010	0.940"	✓			
O	0.69	+/-0.030	0.685"	✓			
P	0.20	+/-0.030	0.170"	✓			
Q	23.00	+/-0.030	23.00"	✓			
R	0.25 x 45°	+/-0.030	0.236"	✓			

<b>Measured by:</b> JF	<b>Audited by:</b> JF	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/10/16	<b>Date:</b> 07/10/16	<b>Date:</b>	N/A

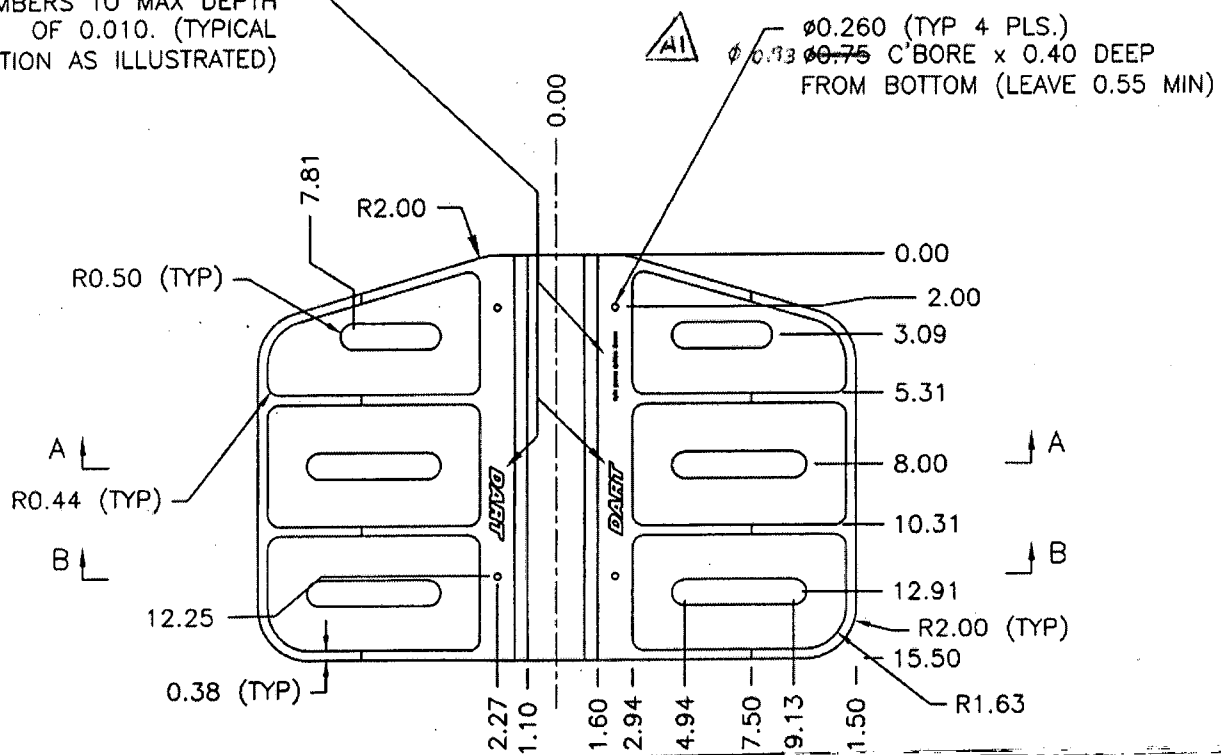
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D135-692-011	KJ/RF	✱



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01 10.18		TITLE BEARPAW	SCALE 1:7
A	01.10.18	NEW ISSUE	
AI	[Signature] 03.01.13	Ø 0.93 WAS Ø 0.75	

RELEASED  
01.10.24 [Signature]

ENGRAVE DART LOGO TO  
MAX DEPTH OF 0.012.  
ENGRAVE PART AND BATCH  
NUMBERS TO MAX DEPTH  
OF 0.010. (TYPICAL  
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)

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WORK ORDER  
NO. 32938

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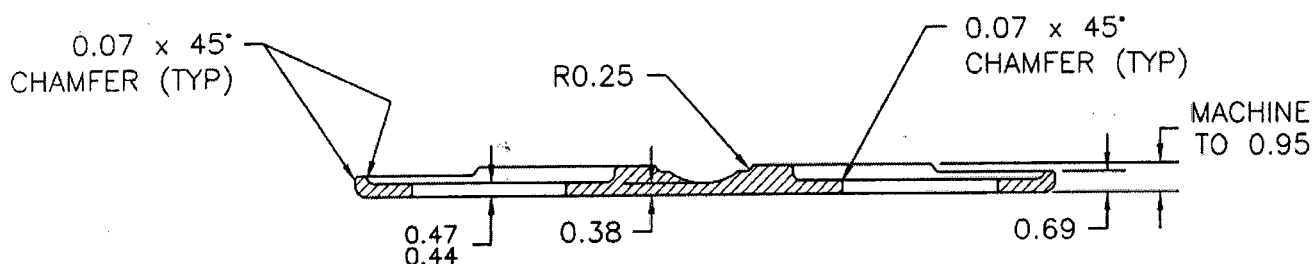
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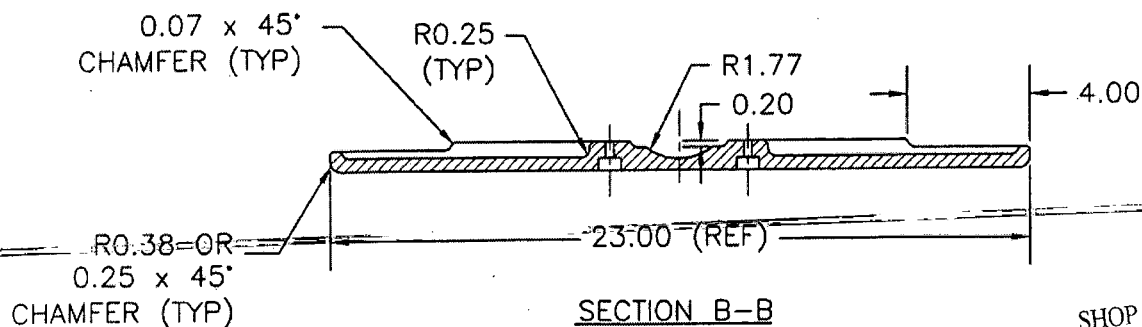


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED  
01.10.24 H



SECTION A-A



SECTION B-B

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